

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017618**Date Inspected:** 25-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as hole restoration 7E-8E/7W-8W and the following observations were made:

7E/8E-E

The QA Inspector randomly observed the ABF welder Song Tao Huang setting up the flux cored arc welding machine at the above identified location. The QA Inspector noted no welding was performed on this date. The QA Inspector noted the ABF welder was mobilizing FCAW equipment from the West bound side of the SAS. The QA Inspector performed a preliminary Inspection of the fit up and noted no discrepancies were located. The QA Inspector noted the fit up appeared in general compliance at a random glance. The QA Inspector noted the official fit up inspection will be completed tomorrow after the fit up is accepted by the SE QC Inspector.

7W/8W-A1

Upon the arrival of the QA Inspector, the ABF welder identified as James Zhen was setting up to perform excavations and weld repairs of previously rejected and indicated weld defects. The QA Inspector randomly observed the ABF welder begin excavating the indicated area of the above identified weld joint. The QA Inspector noted the ABF welder was utilizing a burr bit grinder to perform the weld excavation. The QA Inspector randomly observed the excavation through completion. The QA Inspector performed visual testing and random dimensional verification of the excavation. The QA Inspector randomly observed the first excavation dimensions to be 300mm X 24mm X 20mm deep. The QA Inspector noted the excavation appeared to have been ground and blended to a weldable profile. The QA Inspector noted the Y location of the excavation was Y=0mm-300mm. The QA Inspector

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randomly observed the QC Inspector Tom Pasqualone perform magnetic particle testing of the excavated area to ensure all weld defects had been removed, the QA Inspector noted the QC Inspector did not locate any relevant indications at the time of the testing. The QA Inspector randomly observed the ABF welder preheat and begin performing the shielded metal arc welding (SMAW) repair. The QA Inspector randomly observed the ABF welder to be utilizing 1/8" E7018 low hydrogen electrodes with 135 Amps. The QA Inspector noted the ABF welder spent the remainder of the QA Inspectors shift performing the SMAW repair.

A5

Upon the arrival of the QA Inspector, the ABF welder identified as Jin Pei Wang was setting up to perform excavations and weld repairs of previously rejected and indicated weld defects. The QA Inspector randomly observed the ABF welder begin excavating the indicated area of the above identified weld joint. The QA Inspector noted the ABF welder was utilizing a burr bit grinder to perform the weld excavation. The QA Inspector randomly observed the excavation through completion. The QA Inspector performed visual testing and random dimensional verification of the excavation. The QA Inspector randomly observed the first excavation dimensions to be 410mm X 22mm X 20mm deep. The QA Inspector noted the excavation appeared to have been ground and blended to a weldable profile. The QA Inspector noted the Y location of the excavation was Y=3940mm-4350mm. The QA Inspector randomly observed the QC Inspector Tom Pasqualone perform magnetic particle testing of the excavated area to ensure all weld defects had been removed, the QA Inspector noted the QC Inspector did not locate any relevant indications at the time of the testing. The QA Inspector randomly observed the ABF welder preheat and begin performing the shielded metal arc welding (SMAW) repair. The QA Inspector randomly observed the ABF welder to be utilizing 1/8" E7018 low hydrogen electrodes with 122 Amps.

Summary of Conversations:

no pertinent conversation noted.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
